

Work Order ID 83738

83738

Page 1

April-24-12 1:26:44 PM

Item ID: D3065-7

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Step Spacer

Stop *NS2*

Start Date: 24/04/2012 Start Qty: 50.00

50

Cust Item ID:

Required Date: 08/05/2012 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals:

Process Plan: ML5

Date: 12/04/24

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3065

Rev B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3065

Dwg Rev: B

Prog Rev: B 2-

Deburr if necessary

2024.040

50 0 Jm 12-5-12

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

50 0 Jm 12-5-12

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

50 0 Jm 12-5-12

50 0 Jm 12-5-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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50

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Deburr if necessary.								
140		0.00							
140	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC	Bend as per Dwg D3065								
150		0.00							
150	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

[Handwritten signature]

PTO

48 (2)

12/05/16
SD 12/05/16

counts
(48) (2)

Scrub 17

W/O: 83738

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3265-7

PAR #:

Fault Category: Small Part / water Jet

NCR: ☒ Yes ☐ NoDQA: ☒

Date: 12/05/30

Resolution: Scrap

Disposition: scrap

QA: N/C Closed: ☒

Date: 12/5/30

NCR: 12-1460

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/05/16	130	Sound 3 part with defect when cut & water-jet P.C. for close to edge of disk operation	S AST-417 12/07/17	Scrap & destroy no replace	SS 12/05/16	S 12/07/17	S AST-417 12/07/17	S 12/05/17

NOTE: Date & initial all entries

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Revision ID:

Stop ***NS2***

Item Name: Step Spacer

Start Date: 24/04/2012 Start Qty: 50.00 ***50***

Cust Item ID:

Required Date: 08/05/2012 Req'd Qty: 50 ***50***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00

160

HandFinish

Memo

0.00

Hand Finishing

116 12.5.17

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

48x

12/05/08

180

Identify as per dwg & Stock Location

0.00

180

Packaging

Memo

0.00

Packaging

48x

12/05/08

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

12/5/29
MCS 12/05/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-24-12 1:26:48 PM

Page 1

Work Order ID: 83738

83738

Parent Item: D3065-7

D3065-7

Parent Item Name: Step Spacer

Start Date: 24/04/2012

Required Date: 08/05/2012

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP: C02.11.01Incorporated D3066-1 IPPKJ/RF
IPP Rev:D Now on Water Jet 06-04-11 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	226.1912	0.1574	8.284211			

M2024T3S 040

2024-T3 .040 sheet

Location

Loc Qty

Loc Code

MAT022

226.1911626

117684

21.318421

120196

42.41

120605

66.4627416

121197

96

121197

JM 12/1

12-5-12

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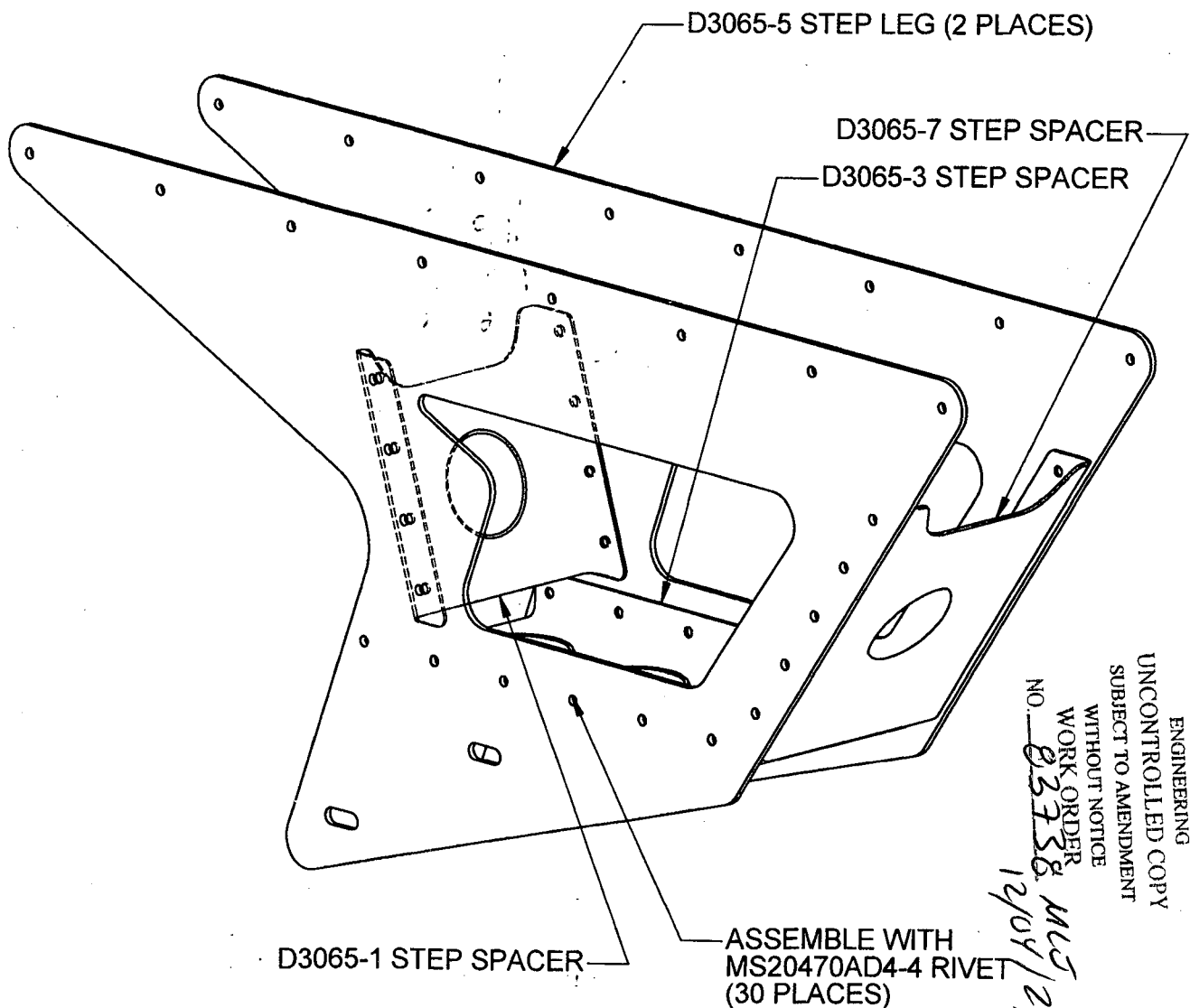
NOTE: Date & initial all entries

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06.06.20 *[Signature]*



D3065-041 STEP LEG ASSEMBLY

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

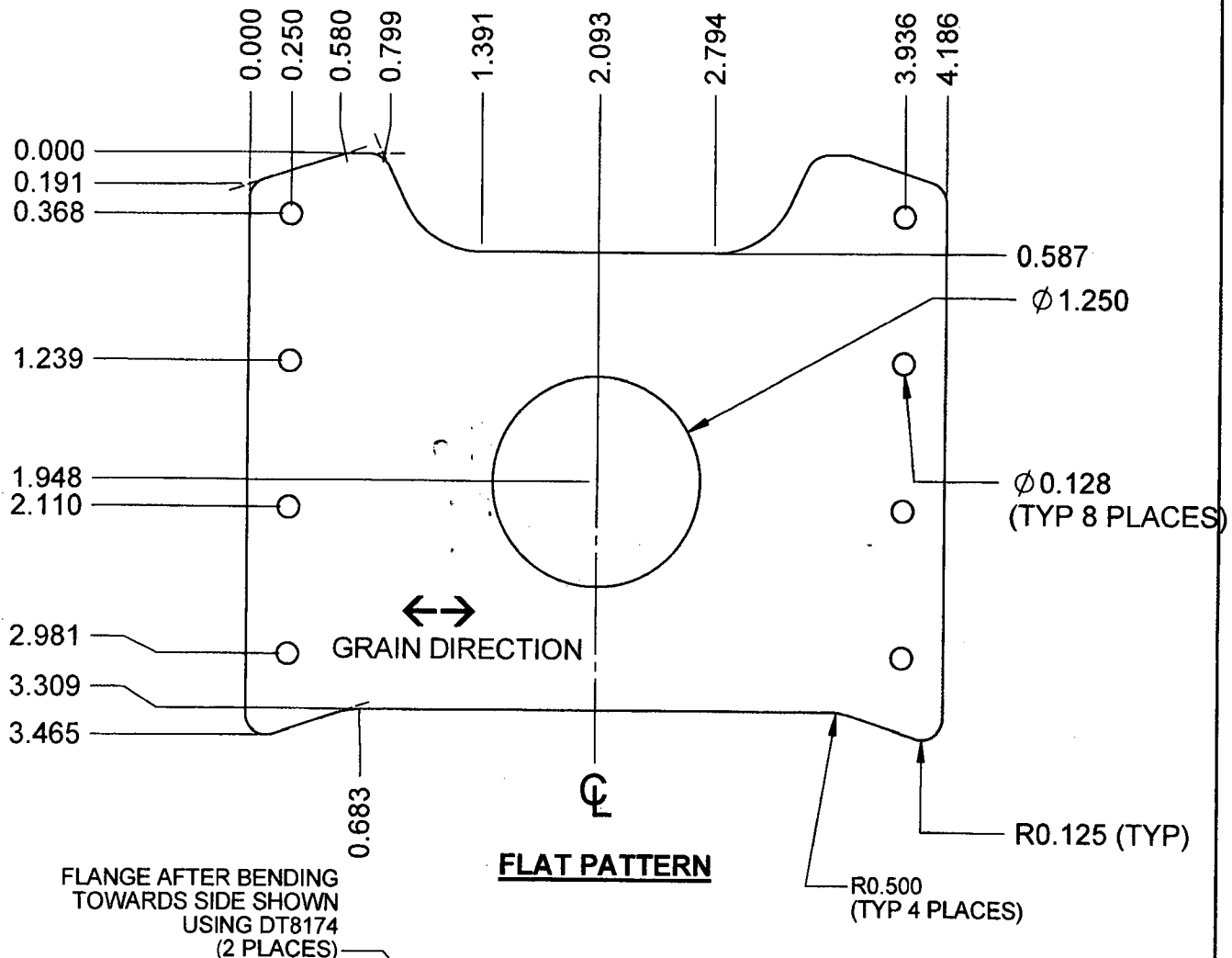
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>#</i>	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

**D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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03738

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

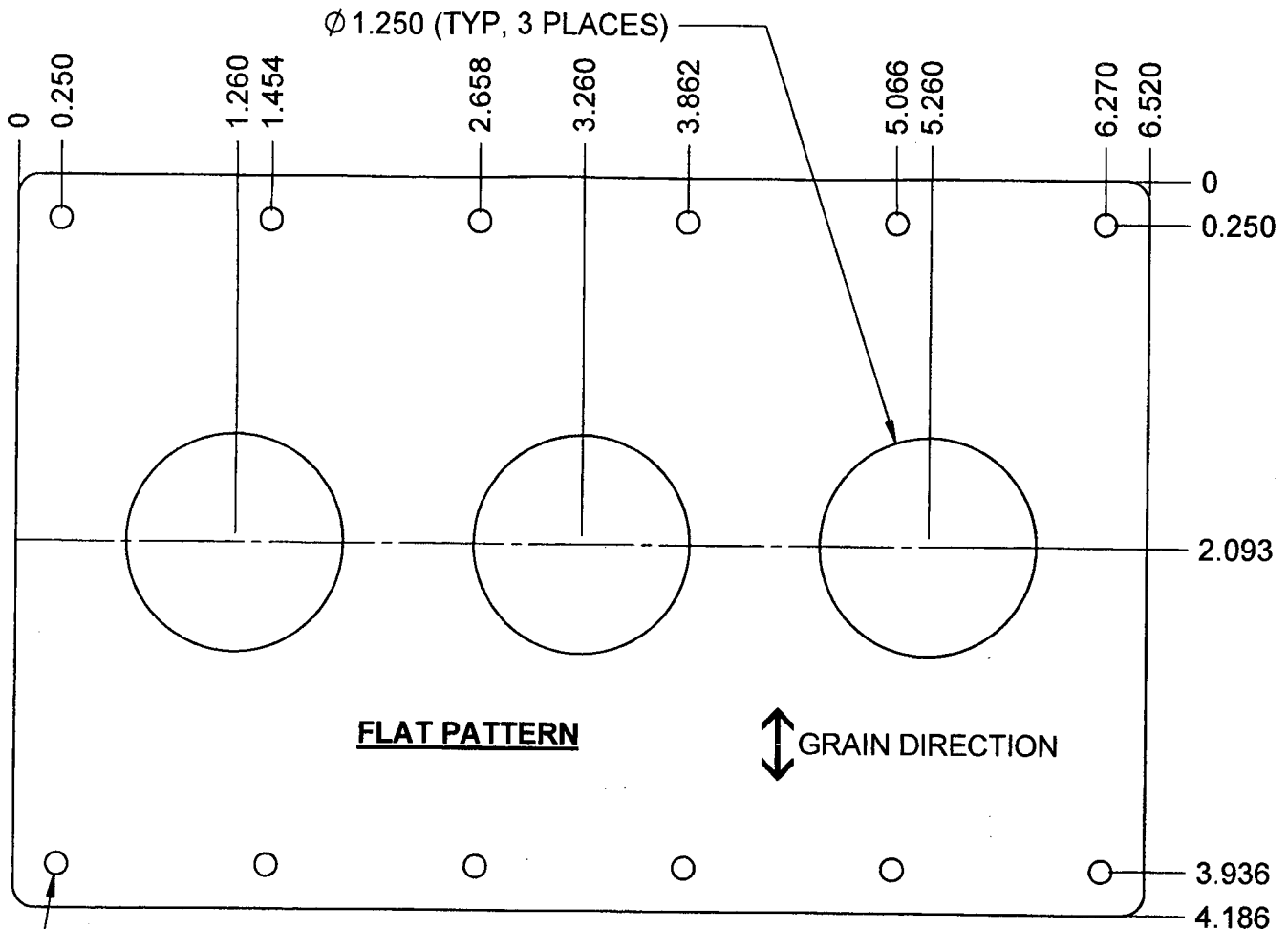
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 3 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:1

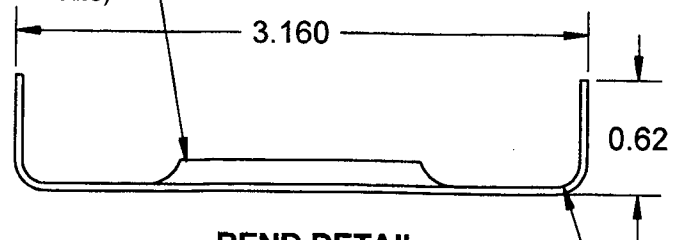


FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES)

Ø 0.129 (TYP, 12 PLACES)

RELEASED

OK to [Signature]



BEND DETAIL

D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

25458

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

Technical drawing of a 55-5 STEP LEG. The drawing shows a complex shape with various dimensions and callouts. Key dimensions include:

- Overall width: 16.458
- Overall height: 8.325
- Top horizontal dimension: 15.750 (2.250 PITCH)
- Bottom horizontal dimension: 6.020 (1.205 PITCH)
- Left vertical dimension: 0.741
- Right vertical dimension: 1.640
- Internal dimensions: 3.484 (0.871 PITCH), 3.460 (0.865 PITCH), 2.770, 0.551, 0.213
- Callouts: $\varnothing 0.128$ (DRILL #30) (TYP 23 PLACES), SEE DETAIL A, DETAIL A (2 PLACES)

55-5 STEP LEG

1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
 (REF DART SPEC M6061T6S.080)
 OR
 5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 6) ALL DIMENSIONS ARE IN INCHES

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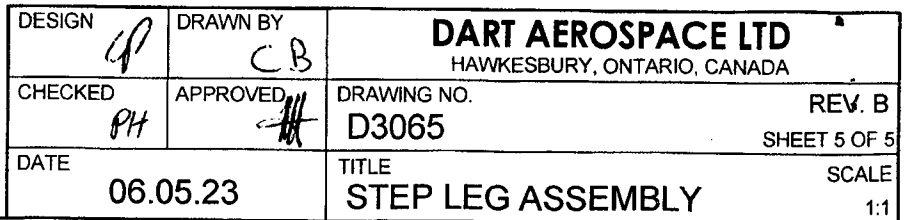
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED

06 06 20 *[Signature]*

0.62

BEND DETAIL

- R0.125 (TYP)

1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
3) PART IS SYMMETRIC ABOUT CENTERLINE
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